



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3368-3
Job Sheet 182509



Part No: D3368-3

Job Qty: 2 ea

Part Name: Pedal Lock Cover



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 8/27/18

Job Tracking No:

Due Date: 9/7/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV B IPP A 05.01.27 New issue KJ/JLM IPP Rev:B 08-07-15 add QC3 DD verified by:ec

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea	9/7/18	9/7/18	0.00	0.00	Start Up Machining-2		SBL 18/10/18
100	Bandsaw	2 pcs	9/7/18	9/7/18	0.00	2.28	Bandsaw1		SBL 18/10/18
105	CNC Vertical Machining	2 pcs	9/7/18	9/7/18	0.00	2.28	HAAS1-3		SBL 18/10/18
110	QC	2 pcs	9/7/18	9/7/18	0.00	0.00	QC2 Machining-2		SBL 18/10/18
120	QC	2 pcs	9/7/18	9/7/18	0.00	0.00	QC8 Machining-2		SBL 18/10/18
130	HandFinish	2 pcs	9/7/18	9/7/18	0.00	0.18	HandFinish1		DR 18/10/22
132	QC	2 pcs	9/7/18	9/7/18	0.00	0.00	QC7-2		SBL 18-10-25
140	Powdercoat	2 pcs	9/7/18	9/7/18	0.00	0.16	Powdercoat6		SBL 18-10-25
150	QC	2 pcs	9/7/18	9/7/18	0.00	0.00	QC3		SBL 18-10-25
160	Packaging	2 pcs	9/7/18	9/7/18	0.00	0.00	Packaging3-1		SBL 18-10-25
170	QC21-SA	2 Ea	9/7/18	9/7/18	0.00	0.00	QC21		SBL 18-10-25

Part Op 100 - cut at 10.450"

Descriptions: 105 - Machine D3368-3 as per Folio FA500 and Dwg D3368 Identify as D3368-3 Deburr

110 - QC2- Inspect parts off machine FAI/FAIB

120 - QC8- Inspect parts - second check

130 - Chemical Conversion Coat per QSI005 4.1

132 - QC7-Inspect Chemical Conversion Coat

140 - Heat oven at temperature for 45 minutes before putting part in oven by: Start Time: 8:30 Oven

Temperature: 380° Finish Time: 9:00

150 - QC3- Inspect Part Finish

160 - Identify as per dwg & Stock Location:

170 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B2.000X02.000	6061-T6 Bar 2.00 X 2.00	1.7420 ft (.871 ea)	90-Start up Operation	5115943 x8

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6B2.000X02.000	2	10	0

Part Specifications

Specifications could not be found.

Plex 8/27/18 11:14 AM Dart.lajeunesse.marie

DART AEROSPACE LTD		Work Order: 182804
Description: Pedal Lock Cover		Part Number: D3368-3
Inspection Dwg: D3368	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
10.25	+/-0.030	10.236	✓		CNC-02	Caliper
7.250	+/-0.010	7.256	✓		VHS-01	Caliper
0.650	+/-0.010	0.643	✓		↓	
0.107	+/-0.010	0.109	✓		VHS-05	Depth gage
1.800	+/-0.010	1.795	✓		VHS-01	
45°	+/-0.5°	45°	✓		CNC-17	Angle Finder
Ø1.300	+/-0.010	1.300	✓		VHS-01	
Ø1.400	+/-0.010	1.395	✓		↓	
Ø1.031	+/-0.010	1.030	✓		VHS-05	
0.250	+/-0.010	0.250	✓		VHS-01	
1.500	+/-0.010	1.4995	✓		↓	
1.440	+/-0.010	1.439	✓		↓	
2.00	+/-0.030	1.988	✓		↓	
7°	+/-0.5°	7°	✓		CNC-17	
0.635	+0.010/-0.000	0.640	✓		VHS-01	
Ø1.250	+/-0.005	1.250	✓		↓	
0.250 deep	+/-0.010	0.250	✓		↓	
1.000	+/-0.010	1.000	✓		↓	
1.450	+/-0.010	1.4515	✓		↓	
0.375	+/-0.010	0.375	✓		↓	
0.310	+/-0.010	0.3027	✓		↓	
Ø0.750	+0.010/-0.000	0.755	✓		↓	
Ø0.185	+0.005/-0.000	0.185	✓		↓	

Measured by: VHS	Audited by: B	Prototype Approval:	N/A
Date: 18/10/17	Date: 18-10-21	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.04.26	New Issue	KJ/JLM	
B	05.05.25	Dimensions and tolerances changed	KJ/JLM	
C	08.07.23	Ø0.201 & Ø0.136 dimensions removed	KJ/DD	

mp 17 June 2019

DQA: _____ Date: _____

QA Closed: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

Work Order update only ☐



Work Order: <u>182509</u>		DISPOSITION		AGAINST DEPARTMENT/PROCESS																	
Part No. <u>D3368-3</u>		Rework ☒ Scrap ☒ Use-as-is ☐		Skid-tube ☐ Machining ☒ Thermoforming ☐ Large Fab ☐		Cross tube ☐ Small Fab ☒ Finishing ☐ Composite ☐		Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐		Engineering ☐ Quality ☐ Other ☐											
NCR No. <u>19-7134</u>		Suspected Unapproved		QTY Effective : _____																	
Date: <u>18-10-18</u>		Step #: <u>110 on 100</u>		Disposition																	
Description Work Order Deviation		Destroyed Scrap																			
Raw material was cut too short																					
Root Cause											FAULT CATEGORY										
Environment ☐		No Re-verification ☐		Pressure/Forced ☐		Temperature/Cure ☐		Power Loss/Surge ☐		Positioned Wrong ☐											
Design ☐		Operator ☒		Bending ☐		Set-up ☐		Folio/Program ☐		Outside Dimensions ☐											
Doc/Data ☐		Offset/Setup ☐		Centre Not Concentric ☐		BOM/Route ☐		Grain ☐		Over/Under tolerance ☐											
Equip/Tooling ☐		Supplier ☐		Cracks ☐		Broken/Damage/Defect ☐		Weld ☐		Part Incorrect ☐											
Handling/Pre ☐		Training ☐		Crimp/Kink/Ripple/Wave ☐		Inspection Incomplete/Unqualified ☐		Wrong Stock Pulled ☐		Part Lost/Missing ☐											
Material ☐		Use for Testing ☐		Cuffs ☐		Contamination ☐		Out of Sequence ☐		Part Moved ☐											
Internal Transport ☐		Poor Information ☐		Crushing ☐		Countersink ☒		Off-set ☐		Drawing ☐											
Tribal Knowledge ☐		Rushing ☐		Heat Treat ☐		Cut Too Short ☐		Mislabeled ☐		Finish ☐											
LOA ☐		Product Improvement ☐		Wave/Twist in Tube ☐		Instructions Incomplete/Unclear ☐		Fit/Function ☐		Misread ☐											
Substation ☐		Process Improvement ☐		Marks/Chatter ☐		Drill Holes ☐		Misaligned/off center ☐		Turning Sequence ☐											
Past Expiry Date ☐		Manufacturing Process ☐		OTHER: ☐																	
Misidentified ☐		Past Due ☐																			
MRB (QS1042) Approval DAS 9 9-89 18-10-18 Completed By SBL 57 9-89 Lead hand / Supervisor Approval Verification 20/18/10/18 Lamarcho QC / QA Coordinator Approval 18-10-18																					

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev 1